

Date: Friday, 04/04/2008 7:37:15 AM  
 User: Jean-Luc Menard

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEAR PLATE
Job Number	: 38331		
Estimate Number	: 11232		
P.O. Number	:	Part Number	: D2365
This Issue	: 04/04/2008 S.O. No. :	Drawing Number	: D2365 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 02/04/2008 Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	:	Material	:
Written By	: <u>08-04-07</u>	Due Date	: 09/04/2008 Qty: 20 Um: Each
Checked & Approved By	:		
Comment	: Est Rev A Removed from 9 Digit 05-12-05 JLM		
	: Est Rev:B Now On Waterjet 08-04-04 JLM		
	: Verified By:EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S063	6061-T6 .063 Sheet
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Comment: Qty.: 0.0049 sf(s)/Unit Total : 0.0987 sf(s)  
 Material: 6061-T6 (QQ-A-250/11) 0.063" thick  
 (M6061T6S.063)  
 Batch: 107276 IB 8-4-4

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D2365  
 Dwg Rev: C  
 Prog Rev: C

IB 8-4-4

(30)

2-Deburr if necessary

08/04/04 (30)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

08/04/04 (30) counter

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per QSI 005 4.1

FD 08/04/07 (30)

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEAR PLATE

Job Number: 38331

Part Number: D2365

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(30)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL 08-04-07.

7.0

FE832EF

PEM Insert



Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s) 60

Pick:

Qty Part Number Description Batch

2 FE832EF PEM Insert M101634

✓ ml 08/04/08

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



x30

Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Insert as per Dwg D2365

ml 08/04/08

9.0

QC5

INSPECT WORK TO CURRENT STEP



counts

Comment: INSPECT WORK TO CURRENT STEP

5 08/04/08 x30

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 38

AS 08/04/08 x30

11.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/10

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



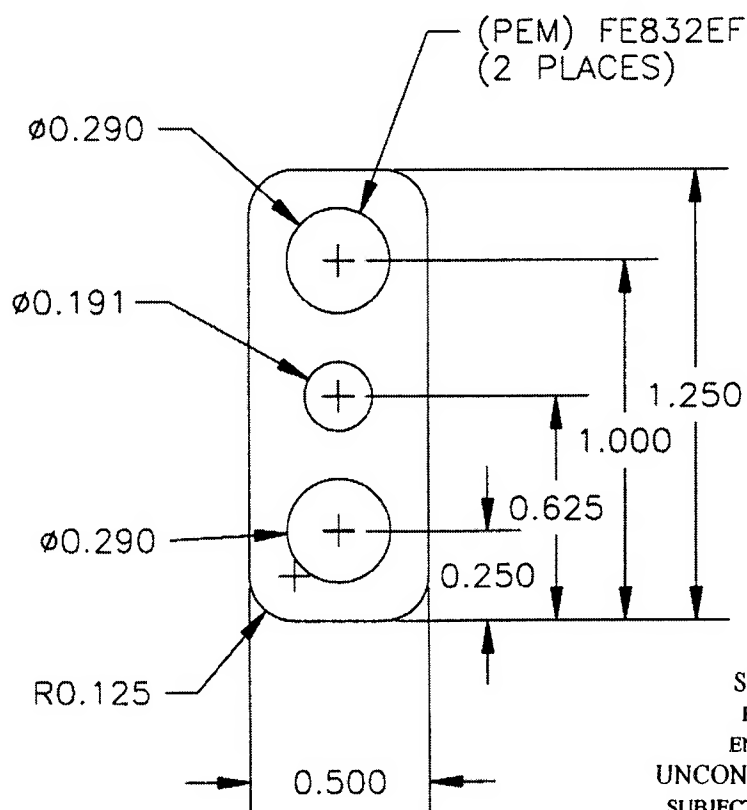
W MF 08-04-09





DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. C
CHECKED Bw	APPROVED [Signature]	D2365	SHEET 1 OF 1
DATE 95:01:20	TITLE WEAR PLATE		SCALE 2:1
C	95:03:06	0.191 WAS 0.197	

RELEASED  
17/04/22 DS



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 3833

6061-T6 (00-A-250/11) 0.063 THICK } # 00.09.26  
ACID ETCH & ALODINE PER QST D05 4.1-1 } #  
INSTALL FE832EF (2 PLS) AFTER ALODINE } # 00.03.07  
~~ALSI 304/316 SS~~  
MATERIAL: 6061-T6 ALUMINUM 0.063 THICK, ANODIZE BLACK.  
AFTER ANODIZING INSTALL (PEM FE832EF) 2 PLACES } #